

Date: Friday, 29/09/2006 9:12:34 AM
User: Linda Lacelle

Process Sheet

Split-2 / 06-10-13

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 28778 -2
Estimate Number : 10530
P.O. Number : N/A
This Issue : 29/09/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : MACHINED PARTS
Previous Run : 28444
Written By :
Checked & Approved By :
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ

Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Part Number : D2571
Drawing Number : D2571 REV E
Project Number : N/A
Drawing Revision : E
Material : N/A
Due Date : 06/10/2006 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2571
Ensure that grain is along 7.75" length
Batch No: B 25354

J.G 06/09/29

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 28778 Double check by: J.F.

- 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
- 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
- 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
- 4-Deburr and remove all machining marks
- 5-Tumble to remove sharp edges.

J.G 06/09/29

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

J.F 06/10/02 / En 06/10/02

Friday, 29/09/2006 9:12:34 AM
Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 28778

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



①

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

2nd 06/10/02

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/10/29

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FC
y 06/10/31 x 1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FC 06/11/23 ①

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PACKAGING RESOURCE #1

FC 6/11/24 ①

9.0

PACKAGING 1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FC 6/11/24 ①

10.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

06/11/27

Job Completion



W 26.11.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-10-13	4.0	W/O split for 1 saddle because of NCR.	J	06-10-13	1	U	J 06-10-13

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/10/13	# 2.0	→ A Flat was machined on edges by skid tube bolting hole offset was wrong. → wrong tool was used to machine D.M "A" 0.250, was machined to 0.234" (0.016" under nominal)	J	Buff Flatness as round as possible. Print acceptable.	En 06/11/13	J 06-10-13	J	J 06-10-13
		tool was changed, only one D2571 reflected.	2				2	

NOTE: Date & initial all entries




05-12 4

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. 06102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125 |
| 3 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
| 4 | CHAMFER 0.063" x 45° ALL AROUND |
| 5 | CHAMFER 0.033" x 45° (SEE DETAIL C) |

 $\triangle E$

Technical drawing of a mechanical part. The main view is a cross-section showing a part with a central cavity and four circular features. Dimensions include a total width of 8.000, a central cavity width of 3.500 ± 0.005, and a distance of 1.750 ± 0.005 between the central cavity and the circular features. A detail view labeled "VIEW B-B" shows a fillet with a radius of R0.66 (TYP) and R0.50 (TYP). The fillet has a width of 1.73 and a height of 0.20. A feature is labeled "PART" and another is labeled "2".

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5	
D	02.09.06	ADD RIDGES: TIGHTEN TOLERANCES	
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177	
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425	
A	96.09.16	NEW ISSUE	
DESIGN	DRAWN BY	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
DS	PH		
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2571	SHEET 1 OF 1
DATE		TITLE	SCALE
05.07.13		OUTER FWD SADDLE	2:1

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DART AEROSPACE LTD

REFERENCE ONLY

DART AEROSPACE LTD	Work Order: 28778
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	0.439	0.439	0.439	0.439		
B	1.745	1.755		1.749	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.499	3.499	3.499		
D	1.745	1.755		1.749	1.749	1.750	1.750		
E	7.990	8.010		7.995	7.998	7.999	7.999		
F	0.490	0.510		0.507	0.502	0.502	0.502		
G	0.257	0.262	DT8683	0.258	0.258	0.258	0.258		
H	0.375	0.380	DT8684	0.377	0.376	0.376	0.376		
I	0.490	0.510		0.492	0.500	0.498	0.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.567	0.567	0.567	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.873	3.872	3.872	3.872		
P	0.115	0.135		0.126	0.126	0.126	0.126		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.254	0.255	0.253	0.254		
S	0.115	0.135		0.122	0.123	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.966	2.960	2.960		
V	0.230	0.250		0.240	0.236	0.239	0.238		
W	0.115	0.135		0.119	0.122	0.121	0.120		
X	0.308	0.313		0.313	0.311	0.310	0.311		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	0.366	0.364	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.635	0.629	0.630	0.629		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.251	0.253		
AE	1.375	1.395		1.388	1.388	1.386	1.387		
AF	0.115	0.135		0.130	0.128	0.128	0.130		
AG	0.240	0.280		0.250	0.250	0.252	0.245		
AH	0.240	0.260		0.250	0.245	0.252	0.251		
AI	2.000	2.020		2.002	2.002	2.001	2.002		
AJ	0.023	0.043		0.035	0.035	0.035	0.035		
Accept/Reject									

Measured by:	mf
Date:	06/10/02

Audited by:	Er
Date:	06/10/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order: 28778
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C	3.495	3.505		3.499	3.499				
D	1.745	1.755		1.749	1.749				
E	7.990	8.010		7.999	7.999				
F	0.490	0.510	DT8683 DT8684	0.502	0.503				
G	0.257	0.262		0.258	0.258				
H	0.375	0.380		0.376	0.376				
I	0.490	0.510		0.500	0.499				
J	1.174	1.184		1.174	1.179				
K	0.558	0.578		0.567	0.567				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.500	1.500				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.872	3.872				
P	0.115	0.135		0.124	0.124				
Q	0.115	0.135		0.135	0.135				
R	0.240	0.260		0.253	0.253				
S	0.115	0.135		0.127	0.124				
T	0.178	0.198		0.188	0.188				
U	2.940	2.980		2.960	2.962				
V	0.230	0.250		0.246	0.237				
W	0.115	0.135		0.122	0.120				
X	0.308	0.313		0.311	0.311	0.310			
Y	0.760	0.765		0.760	0.760	0.765			
Z	0.352	0.372		0.363	0.360				
AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.628	0.628				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.252	0.247				
AE	1.375	1.395		1.385	1.388				
AF	0.115	0.135		0.130	0.125				
AG	0.240	0.280		0.245	0.245				
AH	0.240	0.260		0.252	0.250				
AI	2.000	2.020		2.000	2.002				
AJ	0.023	0.043		0.035	0.035				
Accept/Reject									

Measured by: <i>ml</i>	Audited by: <i>SL</i>
Date: 06/10/07	Date: 06/10/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>[Signature]</i>

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